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UK Patent Application (12) GB (19) 2 205 295 (13) A

(43) Application published 7 Dec 1988

(21) Application No 8713095

(22) Date of filing 4 Jun 1987

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(51) INT CL<sup>4</sup>  
B65D 23/08 B29C 49/06 // B65D 1/40 G09F 3/00

(52) Domestic classification (Edition J):

B8D 18 7PY CW10  
B5A 1R314C6 1R420 8B3 8F T15A  
B8F BX  
B8T FDH  
U1S 1106 1110 1111 1808 B5A B8D B8F B8T

(56) Documents cited

GB A 2067131 GB 1580942 GB 1223359  
GB 0887635 US 4573596 US 4342399  
US 3480168

(58) Field of search

B8D  
Selected US specifications from IPC sub-class  
B65D

(54) Plastics bottles & method of reducing gas permeability *ca, m 4*

(57) The invention provides an injection blow moulded plastics bottle having a label on the outer surface thereof comprising a gas barrier for reducing or preventing the permeation of gasses through that part of the wall of the bottle covered by the label. The invention also provides a method of reducing sorption losses of carbon dioxide from a carbonated drink contained in an injection blow moulded plastics bottle by filling the bottle with carbon dioxide under pressure until the material of the bottle has absorbed some of the carbon dioxide prior to filling the bottle with the carbonated drink. Filling of the bottle with carbon dioxide may be effected during bottle blowing by using carbon dioxide as the blowing medium. Alternatively, the bottle may be filled with carbon dioxide after bottle manufacture but before beverage filling.

PLASTICS BOTTLES & METHOD OF REDUCING  
GAS PERMEABILITY

This invention relates to injection blow moulded plastics bottles and to a method of reducing the gas permeability thereof.

The term "injection blow moulded plastics bottle" as used herein and in the claims hereof means a plastics bottle produced by injection blow moulding or injection stretch blow moulding. The term "bottle" as used herein and in the claims hereof means a bottle, jar or like container.

Injection blow moulded bottles formed from PET (polyethylene terephthalate) are used for containing drinks and foodstuffs such as carbonated drinks, beers, wines, pickles and sauces.

When injection blow moulded PET bottles are used to contain carbonated drinks there is a loss of carbon dioxide from the bottle which limits the shelf life of the product. Normally bottles of carbonated soft drink contain four volumes of carbon dioxide and the normal shelf life criteria is that the bottle should not lose more than 15% volume carbon dioxide in 90 days. Carbon dioxide loss from a carbonated soft drink contained within an injection blow moulded PET bottle occurs by a combination of (a) sorption, i.e. absorption of carbon dioxide into the wall of the bottle, (b) creep, i.e. expansion of the wall of the bottle due to the internal carbon dioxide pressure which increases the head space in the bottle so that carbon dioxide is lost to the head space to re-establish equilibrium conditions within the bottle, (c) closure leakage and (d) permeation loss, i.e. the permeation of carbon dioxide through the wall of the bottle to atmosphere. Carbon dioxide loss due to creep tends to be small and to substantially cease altogether after the first two to three days after carbonation.

whilst carbon dioxide losses due to closure leakage tend to be so small that for practical purposes they can ignored. The loss of carbon dioxide due to sorption tends to be more significant whilst the permeation loss is the most significant of all. The required shelf life can be attained with injection blow moulded PET bottles of larger size containing one litre or more of carbonated drink. However, with smaller size bottles, e.g., containing 250 millilitre or less of carbonated drink, the shelf life becomes unacceptably low because of the larger ratio of surface area to volume of the bottle. It is possible to reduce the permeation loss of injection blow moulded PET bottles by applying a suitable coating to the bottle, e.g., a coating of poly(vinylidene chloride). However, the application of such a coating requires that the bottle first be thoroughly degreased and cleaned of surface contamination such as by washing in a detergent/water solution and the bottles then dried prior to coating. This adds unacceptably to the cost of the bottles in what is a very competitive market. Shelf life can also be increased by increasing the wall thickness of the bottle but this is not desirable because of the high cost of PET polymer.

Other products, such as wines, beers and certain foodstuffs, are subject to biochemical changes due, among other things, to oxidation. For such products it is necessary to reduce as much as possible the ingress of oxygen into the bottle.

The present invention provides an injection blow moulded plastics bottle having a label on the outer surface thereof comprising a gas barrier for reducing or preventing the permeation of gases through that part of the wall of the bottle covered by the label.

The invention also provides a method of reducing the permeation of gases through the wall of an injection blow

moulded plastics bottle, the method comprising applying to the external surface of the bottle a label comprising a gas barrier.

Preferably the bottle is formed from PET polymer, although the invention is equally applicable to bottles formed from other suitable plastics materials..

Said gas barrier may be such as to reduce or prevent the egress of carbon dioxide from the bottle or the ingress of oxygen into the bottle by permeation through that part of the bottle wall covered by the label.

Said gas barrier is preferably a layer of metal or other gas impermeable material. Thus, said layer may comprise a malleable aluminium or other metal foil, e.g., having a thickness up to 0.003 inch (0.076mm) and preferably up to 0.002 inch (0.05 mm). The label may comprise a laminate having a gas impermeable layer as aforesaid and at least one other layer. Said at least one other layer may be a paper layer and/or a plastics layer. For example, the label may comprise a printed outer paper layer, an intermediate layer of metal foil and an inner layer of paper or plastics material.

Said label may cover at least 50%, and preferably at least 60%, of the external surface area of the bottle. The bottle may be designed with as large an external surface as possible suitable for receiving a label, e.g., as large an external cylindrical surface as possible as compared with the bottom and neck portions of the bottle.

The label may be secured to the bottle in any suitable manner but is preferably secured to the bottle by a continuous layer of adhesive.

According to another aspect thereof the present invention provides a method of reducing sorption losses of carbon dioxide from a carbonated drink contained in an injection blow moulded plastics bottle, the method comprising filling the bottle with carbon dioxide under pressure until the material of the bottle has absorbed

some of the carbon dioxide and subsequently filling the bottle with the carbonated drink.

The bottle may be filled with carbon dioxide under pressure during manufacture of the bottle by injection blow moulding the bottle using carbon dioxide as the blowing medium, e.g., at a pressure of about 300 to 400 psi (21 to 28 kg/cm<sup>2</sup>). Alternatively, the bottle may be filled with carbon dioxide under pressure after manufacture of the bottle but prior to filling of the bottle with the carbonated drink.

Carbon dioxide under pressure may be retained in the bottle for a period of time sufficient to ensure that the material of the bottle has become partly or fully saturated with carbon dioxide or until the bottle is filled with carbonated drink.

The invention will be illustrated by reference to the accompanying specific examples, in which examples 1, 5 and 7 are according to the prior art, examples 2, 6 and 8 are according to claims 1 to 22, and examples 3, 4, 9 and 10 are according to claims 23 to 26.

EXAMPLE 1 (Prior Art)

Parameters

bottle capacity	185.00 mls	acceptable % loss 20.00%
carbonation level	4.00 vols	
wt. of bottle	15.30 g	
density of material	1.36	
surface area	25.00 sq in	
wall thickness	14.00 mils	
quoted perm loss	15.00 mls per .001 ins thickness per 100 sq ins per day	
closure leakage	0.10 mls per day	
SHELF LIFE	61.85 days	

Calculation of allowed loss

allowed loss	148.00 mls
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Average internal Pressure Calculation

carbonation level	5.35 atmos
Average internal Pressure	4.82

Sorption calculation

half av. int. press.	2.41 use this figure on graph
Graph figure	4.20
sorption	47.25 mls

Creep calculation  
creep value 14.80 mls  
combined sorption and creep value 62.05 mls

allowed loss less combined  
sorption and creep value 85.95 mls

calculation of permeation loss  
permeation loss 1.29 mls per day  
add closure loss 0.10 mls per day

Total permeation loss 1.39 mls per day

SHELF LIFE 62 days

EXAMPLE 2 (with Gas Barrier Label)

Parameters  
bottle capacity 185.00 mls acceptable % loss 20.00%  
carbonation level 4.00 vols  
wt of bottle 15.30 g  
density of material 1.36  
label area 12.50 sq in  
uncovered surface area 12.50 sq in  
wall thickness 14.00 mils  
quoted perm loss 15.00 mls per .001 ins thickness  
per 100sq ins per day  
closure leakage 0.10 mls per day  
SHELF LIFE 115.39 days

EXAMPLE 3 (bottle saturated with CO<sub>2</sub>)

Parameters  
bottle capacity 185.00 mls acceptable % loss 20.00%  
carbonation level 4.00 vols  
wt of bottle 15.30 g  
density of material 1.36  
surface area 25.00 sq in  
wall thickness 14.00 mils  
quoted perm loss 15.00 mls per .001 ins thickness  
per 100sq ins per day  
closure leakage 0.10 mls per day  
SHELF LIFE 95.85 days

Calculation of allowed loss

allowed loss 148.00 mls

Average internal Pressure calculation

Carbonation level 5.35 atmos

Average internal Pressure 4.82

Sorption calculation - assume total precharge with CO<sub>2</sub>

half av int press                    2.41 use this figure on graph  
Graph figure                        4.20  
sorption                            0.00 mls

Creep calculation

creep value                        14.80 mls  
combined sorption and creep value    14.80 mls

allowed loss less combined  
sorption and creep value    133.2 mls

calculation of permeation loss

permeation loss                    1.29 mls per day  
add closure loss                  0.10 mls per day

Total permeation loss    1.30 mls per day

Shelf life                        96 days

EXAMPLE 4 (gas barrier label and CO<sub>2</sub> saturation)

Parameters

bottle capacity                    185.00 mls acceptable % loss 20.00%  
carbonation level                4.00 vols  
wt of bottle                      15.30 g  
density of material             1.36  
label area                        12.50 sq in  
uncovered surface area        12.50 sq in  
wall thickness                    14.00 mils  
quoted perm loss                15.00 mls per.001 ins thickness  
                                    per 100sq ins per day  
closure leakage                 0.10 mls per day  
SHELF LIFE                        178.82 days

EXAMPLE 5 (prior art)

Parameters

bottle capacity                    185.00 mls acceptable % loss 15.00%  
carbonation level                4.00 vols  
wt of bottle                      15.30 g  
density of material             1.36  
surface area                     25.00 sq in  
wall thickness                    14.00 mils  
quoted perm loss                15.00 mls per.001 ins thickness  
                                    per 100sq ins per day  
closure leakage                 0.10 mls per day  
SHELF LIFE                        34.34 days

EXAMPLE 6 (with gas barrier label)

Parameters

bottle capacity                    185.00 mls acceptable % loss 15.00%  
carbonation level                4.00 vols  
wt of bottle                      15.30, g

density of material	1.36
label area	17.00 sq in
uncovered surface area	8.00 sq in
wall thickness	14.00 mils
quoted perm loss	15.00 mls per .001 ins thickness per 100sq ins per day
closure leakage	0.10 mls per day
SHELF LIFE	93.38 days

EXAMPLE 7 (prior art)

Parameters

bottle capacity	2000.00 mls acceptable % loss 15.00%
carbonation level	4.00 vols
wt of bottle	62.00 g
density of material	1.36
surface area	140.00 sq in
wall thickness	14.00 mils
quoted perm loss	15.00 mls per .001 ins thickness per 100sq ins per day
closure leakage	0.10 mls per day
SHELF LIFE	112.79 days

Calculation of allowed loss

allowed loss 1200.00 mls

Average internal Pressure calculation

carbonation level	5.35 atmos
Average internal Pressure	4.95

Sorption calculation

half av int press	2.47 use this figure on graph
Graph figure	4.20
Sorption	191.47 mls

Creep calculation

creep value	160.00 mls
combined sorption and creep value	351.47 mls

allowed loss less combined  
sorption and creep value 848.53 mls

calculation of permeation loss

permeation loss	7.42 mls per day
add closure loss	0.10 mls per day

Total permeation loss 7.52 mls per day

SHELF LIFE 113 days

EXAMPLE 8 (with gas barrier label)

Parameters

bottle capacity	2000.00 mls acceptable & loss 15.00%
carbonation level	4.00 vols
wt of bottle	62.00 g
density of material	1.36
label area	70.00 sq in
uncovered surface area	70.00 sq in
wall thickness	14.00 mils
quoted perm loss	15.00 mls per.001 ins thickness per 100sq ins per day
closure leakage	0.10 mls per day
SHELF LIFE	222.62 days

EXAMPLE 9 (bottle saturated with CO<sub>2</sub>)

Parameters

bottle capacity	2000.00 mls acceptable & loss 15.00%
carbonation level	4.00 vols
wt of bottle	62.00 g
density of material	1.36
surface area	140.00 sq in
wall thickness	14.00 mils
quoted perm loss	15.00 mls per.001 ins thickness per 100sq ins per day
closure leakage	0.10 mls per day
SHELF LIFE	138.24 days

Calculation of allowed loss

allowed loss 1200.00 mls

Average internal Pressure calculation

carbonation level	5.35 atmos
Average internal Pressure	4.95

Sorption calculation

half av int press	2.47 use this figure on graph
Graph figure	4.20
Sorption	0.00 mls

Creep calculation

creep value	160.00 mls
combined sorption and creep value	160.00 mls
allowed loss less combined sorption and creep value	1040.00 mls

calculation of permeation loss

permeation loss	7.42 mls per day
add closure loss	0.10 mls per day

Total permeation loss 7.52 mls per day

SHELF LIFE 138 days

EXAMPLE 10 (Gas barrier label and CO<sub>2</sub> saturation)

Parameters

bottle capacity	2000.00 mls acceptable	% loss 15.00%
carbonation level	4.00 vols	
wt of bottle	62.00 g	
density of material	1.36	
label area	70.00 sq in	
uncovered surface area	70.00 sq in	
wall thickness	14.00 mils	
quoted perm loss	15.00 mls per .001 ins thickness per 100sq ins per day	
closure leakage	0.10 mls per day	
SHELF LIFE	272.85 days	

It will be clearly seen from the examples that the provision of a gas barrier label according to the present invention significantly increases the shelf life of a carbonated drink contained in an injection blow moulded PET bottle, as does saturating the material of the bottle with carbon dioxide. The combination of both a gas barrier label and saturation of the material of the bottle with carbon dioxide gives even better results.

CLAIMS

1. An injection blow moulded plastics bottle having a label on the outer surface thereof comprising a gas barrier for reducing or preventing the permeation of gasses through that part of the wall of the bottle covered by the label.
2. A bottle according to claim 1 when formed from PET.
3. A bottle according to claim 1 or 2, wherein said gas barrier is such as to reduce or prevent the egress of carbon dioxide or the ingress of oxygen by permeation through that part of the bottle wall covered by the label.
4. A bottle according to claim 1, 2 or 3, wherein said gas barrier is a layer of metal or other gas impermeable material.
5. A bottle according to claim 4, wherein said layer comprises a malleable aluminium or other metal foil.
6. A bottle according to claim 5, wherein said foil has a thickness of 0.002 to 0.003 inch (0.05 to 0.076 mm).
7. A bottle according to claim 4, 5 or 6, wherein said label comprises a laminate having a gas impermeable layer and at least one other layer.
8. A bottle according to claim 7, wherein said at least one other layer is a paper layer and/or a plastics layer.
9. A bottle according to any one of the preceding claims, wherein said label covers at least 50% of the external surface area of the bottle.
10. A bottle according to claim , wherein said label covers at least 60% of the external surface area of the bottle.
11. A bottle according to any one of the preceding claims, wherein said label is secured to the bottle by a continuous layer of adhesive.
12. A method of reducing the permeation of gasses through the wall of an injection blow moulded plastics bottle, the method comprising applying to the external

- surface of the bottle a label comprising a gas barrier.
13. A method according to claim 12, wherein the bottle is formed from PET.
14. A method according to claim 12, wherein said gas barrier is such as to reduce or prevent the egress of carbon dioxide or the ingress of oxygen by permeation through that part of the bottle wall covered by the label.
15. A method according to claim 12, wherein said gas barrier is a layer of metal or other gas impermeable material.
16. A method according to claim 15, wherein said layer comprises a malleable aluminium or other metal foil.
17. A method according to claim 16, wherein said foil has a thickness of 0.002 to 0.003 inch (0.05 to 0.076 mm).
18. A method according to any one of claims 15, 16 or 17, wherein said label comprises a laminate having a gas impermeable layer and at least one other layer.
19. A method according to claim 18, wherein said at least one other layer is a paper layer and/or a plastics layer.
20. A method according to any one of claims 12 to 19, wherein said label covers at least 50% of the external surface area of the bottle.
21. A method according to claim 20, wherein said label covers at least 60% of the external surface area of the bottle.
22. A method according to any one of claims 12 to 21, wherein said label is secured to the bottle by a continuous layer of adhesive.
23. A method of reducing sorption losses of carbon dioxide from a carbonated drink contained in an injection blow moulded plastics bottle, the method comprising filling the bottle with carbon dioxide under pressure until the material of the bottle has absorbed some of the

carbon dioxide and subsequently filling the bottle with the carbonated drink.

24. A method according to claim 23, wherein the bottle is filled with carbon dioxide under pressure during manufacture of the bottle, by injection blow moulding the bottle using carbon dioxide as the blowing medium.

25. A method according to claim 23, wherein the bottle is filled with carbon dioxide under pressure after manufacture of the bottle but prior to filling of the bottle with carbonated drink.

26. A method according to claim 23, 24, 25, wherein the bottle is a bottle according to any one of claims 1 to 11.

27. An injection blow moulded plastics bottle substantially as herein described.

28. A method of reducing the permeation of gasses through the wall of an injection blow moulded plastics bottle, substantially as herein described.

29. A method of reducing sorption losses of carbon dioxide from a carbonated drink contained in an injection blow moulded plastics bottle, substantially as herein described

30. A plastics bottle when produced by the method of claim 24.